Monday, 4/24/2006 10:25:26 AM

₽Jser:

Kim Johnston

Process Sheet

3/2

Customer

: CU-DAR001 Dart Helicopters Services

Job Number Estimate Number : 26761B

: 10442

P.O. Number

:NIA

This Issue

: 4/24/2006

: NC

: N/A : 26416B

S.O. No. : NIA

: MACHINED PARTS Type

Part Number

Drawing Name

Drawing Number

Project Number

Drawing Revision Material

Due Date

Description:

6061-T6 Bar .50" x 6.0"

: D32623

: D3262 REV B

: FUEL PURGE CANISTER

: N/A

:NIA : 5/15/2006

Qty:

4 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

Removed P/O for liquid penetrant inspection

J/JLM

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

M6061T6B0500X06000

Comment: Qty.:

0.9668 f(s)/Unit Total: 3.8674 f(s)

Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick

(M6061T6B0.500x06.000) Identify for D3262-3

Batch: m 100 817

BAND SAW 2.0



Comment: BAND SAW

Cut blanks: 6.000" x 0.500" x 5.400" long Bar Machine as per Folio FA457 and Dwg D3262

Identify for D3262-3

Deburr

3.0 QC2

SECOND CHECK

PACKAGING RESOURCE #1

BAND SAW

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

Comment: SECOND CHECK PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location: WH 18

Page 1

₹:5.0

Dart Aerospace Ltd

W/O:			WC	ORK ORDER CHANGE	S			
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•								
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: <u>(</u>	06/05/18
							Date: _	
NCR:		V	VORK ORDI	ER NON-CONFORMAI	NCE (NCR)			•
DATE	STEP	Description of NC		Corrective Action Section		Verification	n Approval	Approval
DATE	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
					·			
						-	·	
							·	

NOTE: Date & initial all entries

Date:

Monday, 4/24/2006 10:25:26 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 26761B

Part Number: D32623

Job Number:



Seq. #:

Machine Or Operation:

Inspection Level 21

Description:

6.0

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL



Job Completion



U 06.05.18

Dart Aerospace Ltd

	F								
W/O:			WC	ORK ORDER CHANG	ES				
DATE STEP		PRO	OCEDURE CHAI	NGE	By Date Qty			Approval Chief Eng / Prod Mgr Approva QC Inspect	
Part No	•	PAR #:	Fault Cateç	gory:	_ NCR: Ye	s No DC	A:	Date: _	J
					QA:	QA: N/C Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NO	R)			
DATE	STEP	Description of NC		Corrective Action Section B			cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		tion C	Chief Eng	QC Inspector
					,				
	1		· 1					1	1

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26761B	
Description: Cap	Part Number:	D3262-3	
Inspection Dwg: D3262 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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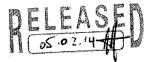
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010					
0.45	+/-0.030					
R0.063	+/-0.010					\(\)
0.090	+/-0.010				. \ \	(Y)
0.33	+/-0.030				7///	
5.005	+0.010/-0.000					<u></u>
0.688	+0.015/-0.000			6	10/1	
3.250	+/-0.005			, ·	<i></i>	
0.875	+/-0.010		(<u> </u>		
Ø0.516	+0.005/-0.000		//			
Ø5.190	+/-0.010		5/			
			~			
0.83	+0.015/-0.000					
Ø0.580	+0.005/-0.000	7)			
Ø5.005	+0.010/-0.000	9				
	1	γ				
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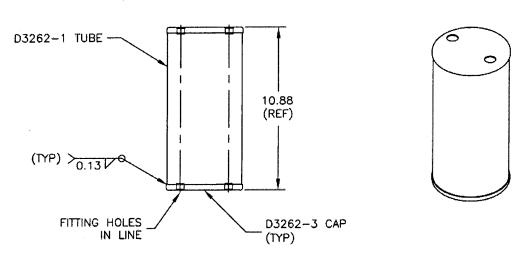
Measured by: JL	Audited by:	E	Prototype Approval:	N/A
Date: 06/04/30	Date:	06/0430	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.09.03	New Issue	P/O D3262-041	KJ/JLM	1
В	05.04.28	Dimensions and	I tolerances revised	KJ/JLM A	

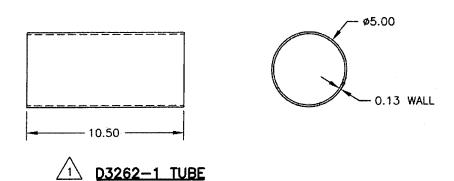


DESIG	N N	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHEC	KED W	APPROVED.	DRAWING NO. REV. E			
	4	#	D3262 SHEET 1 OF 2			
DATE		1 79	TITLE SCALE			
05.0	02.14		FUEL PURGE CANISTER 1:			
Α		04.05.06	NEW ISSUE			
В		05.02.14	ADD PRESSURE TESTING OPTION			





D3262-041 CANISTER ASSEMBLY



D3262-041:

1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8) TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)

SHOP COPY **RETURN TO**

2) WELD PER QSI 004.

3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi

ENGINEERING

AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

UNCONTROLLED COPY

4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

SUBJECT TO AMENDMENT

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

WITHOUT NOTICE

WORK ORDER

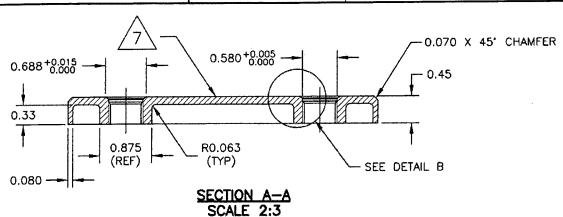
6) ALL DIMENSIONS ARE IN INCHES
7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

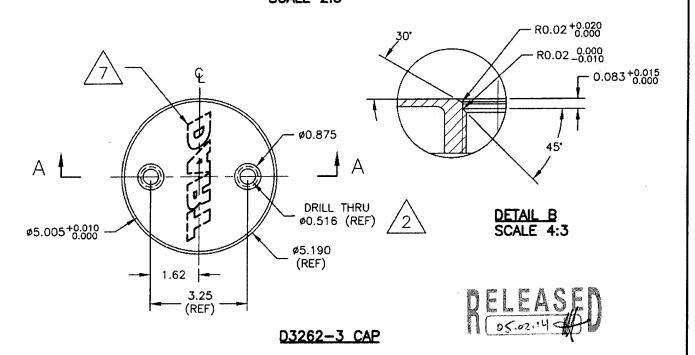
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DESIGN TA	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO,	
CHECKED M	APPROVED	DRAWING NO.	REV. B
#	#	D3262	SHEET 2 OF 2
DATE		TITLE	SCALE
05.02.14		FUEL PURGE CANISTER	1:3





D3262-3

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR SHOP COPY RETURN TO (REF. DART SPEC. M6061T6B)

2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879

ENGINEERING

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED CONTROLLED COPY ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SUBJECT TO AMENDMEN

6) PART IS SYMMETRIC ABOUT CENTERLINE

WITHOUT NOTICE

7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP WORK ORDER (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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